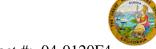
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453

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Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-011513 Address: 333 Burma Road **Date Inspected:** 18-Jan-2010

City: Oakland, CA 94607

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Xu Xian Ping **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A Yes N/A N/A **Electrode to specification:** No Weld Procedures Followed: Yes No N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** OBG Sub-Assembly

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

Non-Destructive Testing:

Ultrasonic Testing (UT) pursuant to NDT Inspection Notification Sheet (Document No. 005075):

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

1. CB202A-014-002, 014

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) of 20TR3-004; Weld 017, 015. Welder is identified as 051356. ZPMC Quality Control (QC) is identified as Guo Yuan Ting. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 20TR2-004; Weld 011. Welder is identified as 214945. ZPMC Quality

WELDING INSPECTION REPORT

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Control (QC) is identified as Guo Yuan Ting. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of FB204-044; Weld 063, 065. Welder is identified as 204338. ZPMC Quality Control (QC) is identified as Guo Yuan Ting. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-B-U2-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of FB204-043; Weld 063, 065. Welder is identified as 204338. ZPMC Quality Control (QC) is identified as Guo Yuan Ting. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-B-U2-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of FB204-042; Weld 063, 065. Welder is identified as 204338. ZPMC Quality Control (QC) is identified as Guo Yuan Ting. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-B-U2-F. Welding appears to conform to the requirements of the WPS used.

This QA Inspector observed Magnetic Particle Testing (MT) performed by ZPMC MT Technician Jin Jian Ting of LD3022-001 (side A); 12 Welds tested with MT indications identified as rejects by the ZPMC MT Technician at the following locations:

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1. Weld 007; Y=140; L=12mm; LLI (Longitudinal Linear Indication) 11. Weld 013; Y=3200; Diam=4mm; PO
(Porosity)
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2. Weld 007; Y=1000; L=14mm; TLI (transverse linear indication)
                                                                12. Weld 013; Y=1860; L=5mm; TLI
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This QA Inspector also observed Magnetic Particle Testing (MT) performed by ZPMC MT Technician Jin Jian Ting of LD3023-001 (side A); 12 Welds tested with MT indications identified as rejects by the ZPMC MT Technician at the following locations:

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1. Weld 005; Y=3900; L=12mm; TLI (Transverse Linear Indication)
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- 2. Weld 021; Y=480; L=11mm; LLI (Longitudinal Linear Indication)
- 3. Weld 025; Y=2650; L=14mm; LLI
- 4. Weld 025; Y=1550; L=4mm; TLI
- 5. Weld 014; Y=3300; L=5mm; TLI
- 6. Weld 012; Y=1850; Diam=3mm; PO (Porosity)
- 7. Weld 012; Y=0; L=4mm; LLI

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable

WELDING INSPECTION REPORT

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contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Holmes,Stefan	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer